

Work Order ID 70593 - 2

Wednesday, July 06, 2011 8:37:45 AM

Split



Page 1

Item ID: D412-630-034

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step RH Folding

Start Date: 6/10/2011 Start Qty: 3.00

Required Date: 7/11/2011 Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & create labels per PPP D412-630-034 CHG003

5/10/12

H Cor BG 11-8-12  
①

110

0.00



Small Fab

Small Fab

Small Fab

Memo

0.00

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M109929

COAT exposed HARDWARE WITH LPS PROCYON

A/R LPS PROCYON BATCH: M114596

EP 11/07/12 ①  
EP 11/08/11 ②

**Work Order ID 70593**

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Page 2

Item ID: D412-630-034

Accept

Revision ID:

Item Name: Heli Access Step RH Folding

Start Date: 6/10/2011 Start Qty: 3.00

Required Date: 7/11/2011 Req'd Qty: 3.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

140

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control



Cust Item ID:

Customer:



Sullosly

+1  
RH

11/8/12 RSP

Sullosly

+1  
RH

**Work Order ID 70593**

Wednesday, July 06, 2011 8:37:45 AM



Page 3

Item ID: D412-630-034

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step RH Folding

Start Date: 6/10/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D412-630-034

Location:

PPP Rev: A

160



QC

Quality Control

QC21 - Final Inspection - Work Order Release

0.00

Memo

0.00

11/8/12 SP 10

11/8/16 JJ

ME  
11-08-15

# Picklist Print

Wednesday, July 06, 2011 8:37:41 AM

Page 1

Work Order ID: 70593

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding



Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A New Issue 06-11-08 JLM  
 IPP rev B ecn1019, added D2807-041 EC verified by:DD  
 IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C8  Nut		Purchased	No			110	Each	33.0000	2	6			
<div> <div>Location</div> <div>ST324</div> <div>117771</div> <div>118091</div> </div> <div> <div>Loc Qty</div> <div>33</div> <div>23</div> <div>10</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
AN3C21A  BOLT		Purchased	No			110	Each	77.0000	2	6			
<div> <div>Location</div> <div>ST352</div> <div>109148</div> <div>117366</div> <div>117514</div> </div> <div> <div>Loc Qty</div> <div>77</div> <div>7</div> <div>20</div> <div>50</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
AN8C16  Bolt		Purchased	No			110	Each	37.0000	2	6			
<div> <div>Location</div> <div>ST345</div> <div>106066</div> </div> <div> <div>Loc Qty</div> <div>37</div> <div>37</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

EP 11/07/19

64

EP 11/07/19

64

EP 11/07/19

64



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, July 06, 2011 8:37:41 AM

Page 2

Work Order ID: 70593

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

D2012-107

Manufactured No

110 Each

15.0000

1 3



Clevis

Location

Loc Qty

Loc Code

WA005

15

66811

15

D2803-042

Manufactured No

110 Each

3.0000

1 3



Bracket Assembly

Location

Loc Qty

Loc Code

ST149

3

64093

1

71008

2

D2804-042

Manufactured No

110 Each

1.0000

1 3



Bracket Assembly

Location

Loc Qty

Loc Code

ST149

1

69400

1

D2807-041

Manufactured No

110 Each

25.0000

2 6



Door prop

Location

Loc Qty

Loc Code

ST022

17

60540

2

69671

15

ST023

8

68494

8

Wednesday, July 06, 2011 8:37:41 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

Wednesday, July 06, 2011 8:37:41 AM

Page 3

Work Order ID: 70593

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

D2813

Manufactured No

110 Each

21.0000

2 6



Washer

Location

Loc Qty

Loc Code

ST023

21

69386

21

110 Each

60.0000

4 12

D3395-1

Manufactured No



Bushing

Location

Loc Qty

Loc Code

ST052

60

69387

20

70775

40

110 Each

0.0000

1 3

D3562-042

Manufactured No



Step Assembly, RH

MS21043-3

Purchased No



Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1061

112314

69

118077

992

110 Each

184.0000

2 6

MS24665-302

Purchased No



Cotter Pin

Location

Loc Qty

Loc Code

ST357

184

117460

184

Wednesday, July 06, 2011 8:37:42 AM

Shop Packet Print

Page 3



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, July 06, 2011 8:37:42 AM

Page 4

Work Order ID: 70593

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

MS24693-C280

Purchased

No

110

Each

41.0000

2

6



Screw



*SP 11/07/11*

*64*

## Location

## Loc Qty

## Loc Code

ST310

40

115594

10

118093

30

ST318

1

111279

1

NAS1515H3

Purchased

No

110

Each

166.0000

6

18



Washer



*SP 11/07/11*

## Location

## Loc Qty

## Loc Code

ST277

166

116373

6

117460

60

118078

100

NAS1515H5L

Purchased

No

110

Each

68.0000

4

12



WASHER



*SP 11/07/11*

## Location

## Loc Qty

## Loc Code

FG

40

103691

40

ST277

28

111359

28

*28*

Wednesday, July 06, 2011 8:37:42 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Wednesday, July 06, 2011 8:37:42 AM

Page 5

Work Order ID: 70593

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

NAS1515H8

Purchased

No

110

Each

227.0000

4

12



Washer

## Location

## Loc Qty

## Loc Code

ST278

227

111275

35

111411

192

AN44C7A

Purchased

No

130

Each

65.0000

1

8



Eyebolt

## Location

## Loc Qty

## Loc Code

ST362

65

109013

25

111308

40

AN4C10A

Purchased

No

130

Each

73.0000

1

3



Bolt

## Location

## Loc Qty

## Loc Code

ST356

73

112243

43

114523

30

AN4C15A

Purchased

No

130

Each

93.0000

2

6



Bolt

## Location

## Loc Qty

## Loc Code

ST358

93

115835

11

117441

32

117795

50

Wednesday, July 06, 2011 8:37:42 AM

Shop Packet Print

Page 5



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

Wednesday, July 06, 2011 8:37:42 AM

Page 6

Work Order ID: 70593

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

AN4C6A

Purchased

No

130

Each

410.0000

1

3



Bolt

## Location

## Loc Qty

## Loc Code

FG

4

103344

4

ST306

12

117313

12

ST356

394

116704

19

117619

150

117794

50

117872

75

118191

100

AN5C15A

Purchased

No

130

Each

65.0000

2

6



Bolt

## Location

## Loc Qty

## Loc Code

ST338

20

118191

20

ST339

45

111819

7

117764

13

117885

25

D2806-1

Manufactured

No

130

Each

26.0000

2

6



Bushing

## Location

## Loc Qty

## Loc Code

ST022

26

68492

6

70885

20

Wednesday, July 06, 2011 8:37:42 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, July 06, 2011 8:37:42 AM

Page 7

Work Order ID: 70593

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

D2806-3

Manufactured No

130 Each

27.0000

2

6



Bushing

Location

Loc Qty

Loc Code

ST022

27

69401

7

70886

20

D2810-5

Manufactured No

130 Each

8.0000

1

3



Strut

Location

Loc Qty

Loc Code

ST265

8

52034

1

69402

7

D3396-1

Manufactured No

130 Each

38.0000

2

6



Spacer

Location

Loc Qty

Loc Code

ST052

38

46748

8

69906

30

MS21043-4

Purchased No

130 Each

897.0000

4

12



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

857

117601

357

117793

500

Wednesday, July 06, 2011 8:37:42 AM

Shop Packet Print

Page 7



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, July 06, 2011 8:37:42 AM

Page 8

Work Order ID: 70593

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

MS21043-5

Purchased

No

130

Each

583.0000

3



Nut

## Location

## Loc Qty

## Loc Code

FG

20

101418

20

ST301

463

112314

363

116548

100

ST314

100

118159

100

NAS1515H4

Purchased

No

130

Each

180.0000

7

21



Washer

## Location

## Loc Qty

## Loc Code

ST277

180

111525

2

116169

3

117460

50

117735

75

118078

50

NAS1515H5

Purchased

No

130

Each

167.0000

7

21



Washer

## Location

## Loc Qty

## Loc Code

FG

40

103286

20

103691

20

ST277

127

103286

100

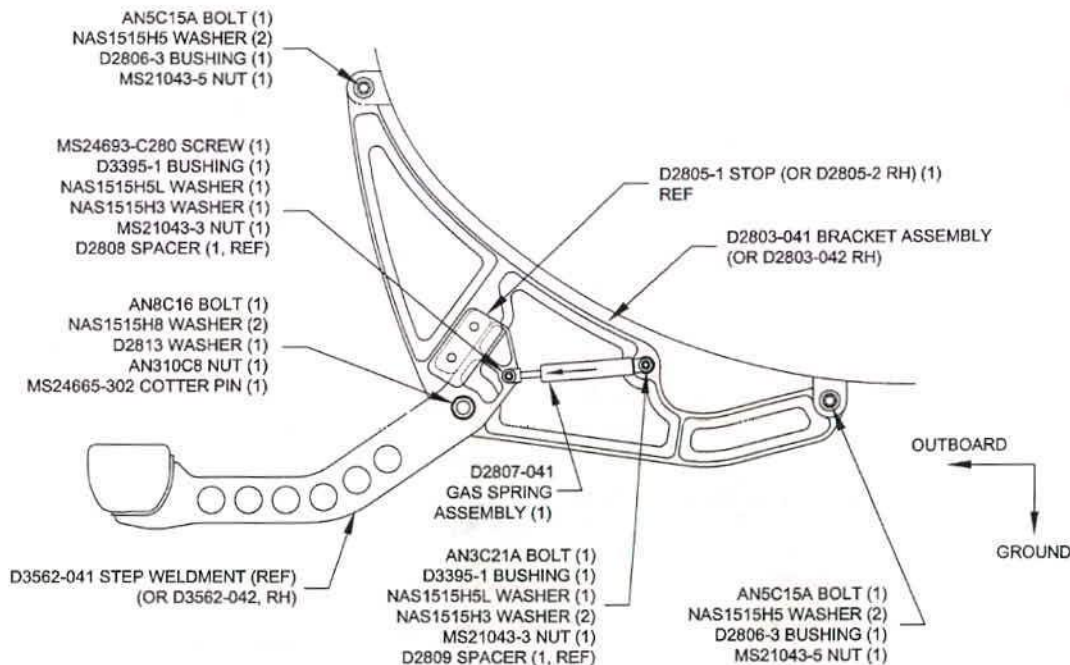
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27

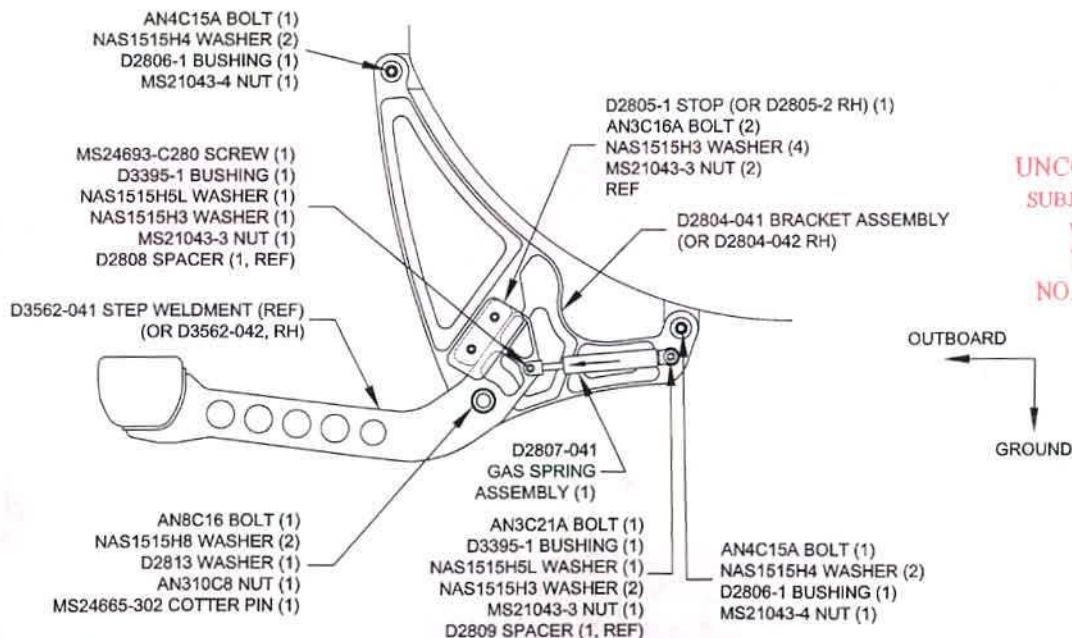
Wednesday, July 06, 2011 8:37:42 AM

Shop Packet Print

Page 8

**D412-630-033/-034 Heli-Access-Step™ Installation**

**FIGURE 25-13: STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)



**FIGURE 25-14: STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70593

*pl-11-06-12*

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**25-00-00**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

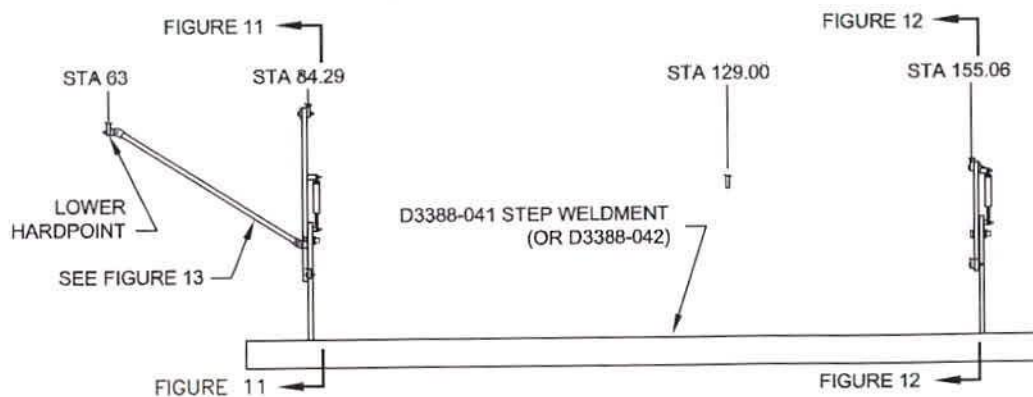
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

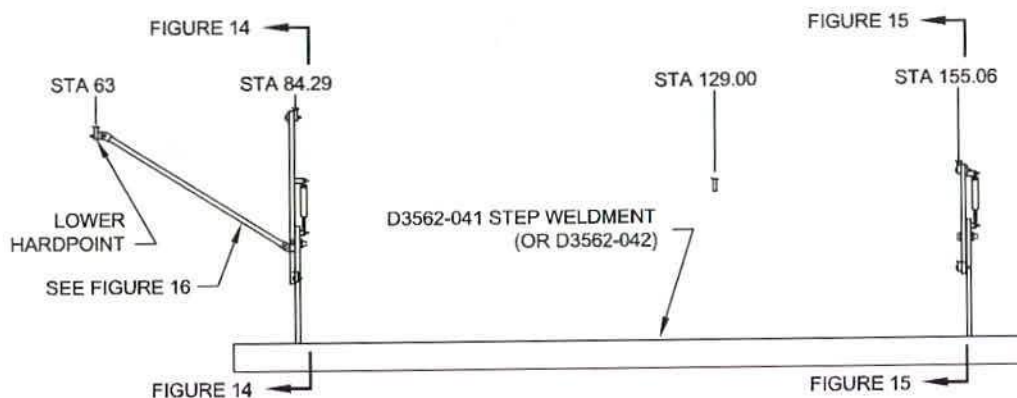
**NOTE:** Date & initial all entries



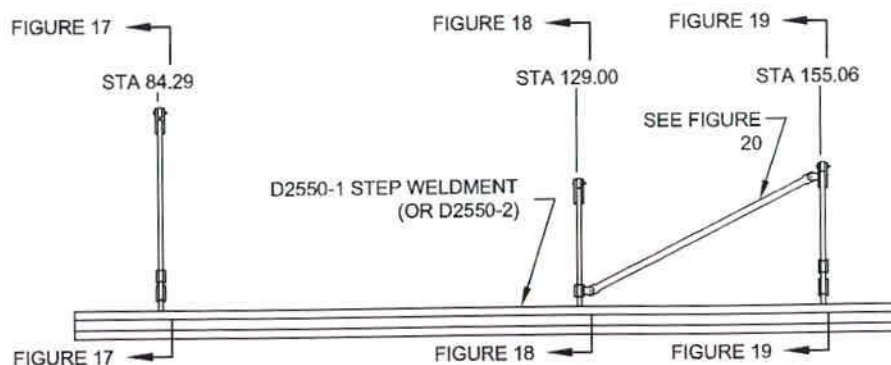
**D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-033 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-034 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)**  
**D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)**



**FIGURE 3 – D412-630 Heli-Access-Step™ Installations**

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Revision: **M**  
 Date: 08.12.12

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

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